



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2665-2
Job Sheet 197389



Part No: D2665-2

Job Qty: 3 pcs ✓

Part Name: Saddle, RH, Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 7/19/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	3 pcs	7/19/19		1.00	6.48	HAAS - 1		SBL 19/07/00
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	3 pcs	7/19/19		0.00	0.32	Conventional Mill - 1 - B4B		SBL 19/07/00
							Conventional Mill - 2 - B4B		
120	QC 2	3 pcs	7/19/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S196278



Part: D2665-2

Job No: 197389

Serial No/Batch: S196278

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/06/19

130	QC 8	3 pcs	7/19/19	0.00 0.00	QC 2 - 57	SBL 19/07/06
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
140	Handfinish - 1-1 Chemical-B4B	3 pcs	7/19/19	0.00 0.23	QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	H/S 19/7/9
					QC 8 - 57	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	JUL 10 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)-	3	7/19/19	0.00 0.14	Powdercoat - 1 - B4B	

B4B

M175459.

pcs

START: 9.55 OUT: 3.30 FINISH: 10.25

160 QC 3

3

pcs

7/19/19

0.00 0.00

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

DAS
81
9-89

JUL 11 2019

170 Packaging 3-1 - Stock - B4B

3

pcs

7/19/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	3 pcs	7/19/19	0.00 0.00	QC 21 - SA - 21	JUL 19 2019 DAS 21
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - HAAS CNC Vertical Machine - 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per Descriptions: attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached 110 - Manufacture as per dwg Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-003	Saddle Billet, 7075	3 pcs (1 ea)	100-HAAS 4 Axis	5175 541 5175 541	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-003	3	50	0	
Part Specifications					
Specifications could not be found.					

Plex 7/5/19 11:46 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order: 197389
Description: 206 Saddle, Outboard, Right side		Part Number: D2665-2
Inspection Dwg: D2665	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.120	.119		
B	0.100	0.140		.121	.125	.124		
C	1.125	1.145		1.135	1.135	1.135		
D	0.615	0.685		.680	.680	.680		
E	0.240	0.260		.250	.250	.250		
F	1.313	1.343		1.323	1.322	1.322		
G	0.210	0.230		.221	.221	.221		
H	0.100	0.180		.130	.130	.130		
I	2.470	2.510		2.492	2.495	2.495		
J	1.565	1.585		1.575	1.575	1.575		
K	0.235	0.240		.238	.238	.238		
L	0.100	0.120		.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.00		
N	0.510	0.515		.510	.510	.510		
O	5.990	6.010		5.996	5.996	5.996		
P	1.245	1.255		1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500		
R	0.312	0.318		.312	.312	.312		
S	0.315	0.322		.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362		
V	0.787	0.807		.794	.793	.794		
W	0.540	0.560		.548	.548	.548		
X	1.674	1.684		1.679	1.679	1.679		
Y	0.256	0.262		.257	.257	.257		
Z	0.912	0.932		.921	.922	.920		
AA	0.490	0.510		.499	.501	.502		
AB	0.178	0.198		.188	.188	.188		
AC								
AD								
AE								

DAS
57
9-89

Accept/Reject

Measured by: 9-89	Date: 19/07/06
Audited by:	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	